

Date: Monday, 10/11/2008 3:34:42 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	RH ACTUATOR ASSEMBLY	
<b>Job Number</b> :	43287			
<b>Estimate Number</b> :	12770			
<b>P.O. Number</b> :		<b>Part Number</b> :	41232 200 001 002	
<b>This Issue</b> :	10/11/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	41232-200-001 REV IR	
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	42219	<b>Drawing Revision</b> :	IR	
	<b>Type</b> :	<b>Material</b> :		
	SMALL /MED FAB	<b>Due Date</b> :	28/11/2008	<b>Qty:</b> 2 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	JUD 08.11.11			
<b>Comment</b> :	Est Rev:A New Issue 07-02-28 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MS208224	elbow
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) elbow Batch: M110363 9/1/09 SP		
2.0	AN8424D	Elbow
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Elbow Batch: M110363 9/1/09 SP		
3.0	41232 200 007 001	Brass Cylinder Assembly
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Brass Cylinder Assembly Batch: 39219-1 B42266 9/1/09 SP		
4.0	41232 200 003 001	Spring (Step Actuator)
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Spring (Step Actuator) Batch: 30941 9/1/09 SP		
5.0	MS1699623	cap screw
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) cap screw Batch: M1103934 9/1/09 SP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 3:34:42 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43287

Part Number: 41232 200 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	AN3154R	Nut
-----	---------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M17566

SS 08/12/01 (X2)

7.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M109249

SS 08/12/01 (X2)

8.0	AN960JD10	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M109061

SS 08/12/01 (X2)

9.0	MS21042L3	Nut
-----	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M109031

SS 08/12/01 (X2)

10.0	AN322A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M106043

SS 08/12/01 (X2)

11.0	41232 200 005 003	Spacer (Step Actuator)
------	-------------------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer (Step Actuator)

Batch:

B43732

SS 08/12/01 (X2)

12.0	41232 200 002 005	pivot arm
------	-------------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

pivot arm

Batch:

31978

B43305

9/1/09

SS

SS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/11/2008 3:34:42 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43287

Part Number: 41232 200 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	41232 200 002 003	latch
------	-------------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

latch

Batch:

B39216 x1 B43307 18

8/12/19

JS 08/12/01 (R2)

14.0	41232 200 002 001	tube
------	-------------------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

tube

Batch:

B43303

JS 08/12/01 (R2)

15.0	41232 200 008 001	Decal
------	-------------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Decal

Batch:

31023

JS 08/12/01 (R2)

16.0	S 1455	spring-step actuator (replaces 71459)
------	--------	---------------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH:

104079

JS 08/12/01 (R2)

17.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 09/01/29

(2)

18.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/02 (R2)

19.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 43268

8/2/02

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/11/2008 3:34:42 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43287

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 09-02-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

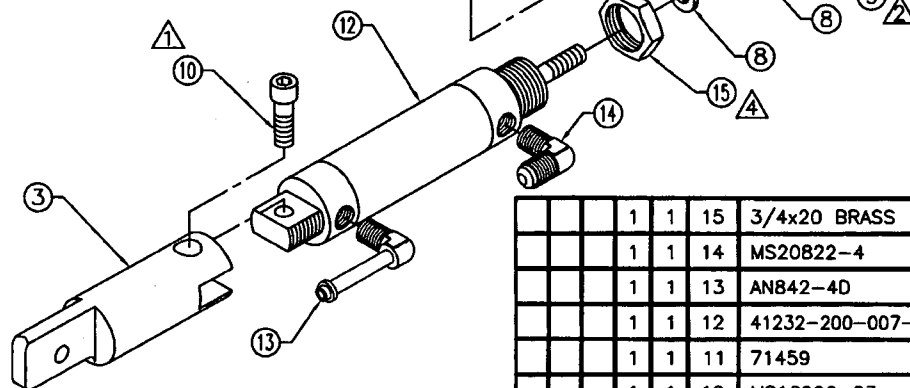
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

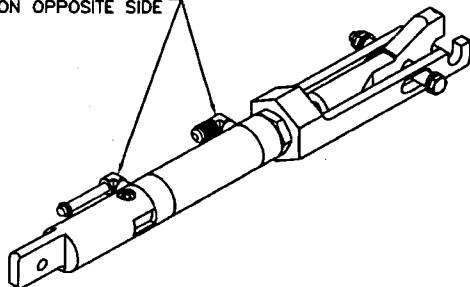
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









INSTALL ITEM #12  
ON OPPOSITE SIDE

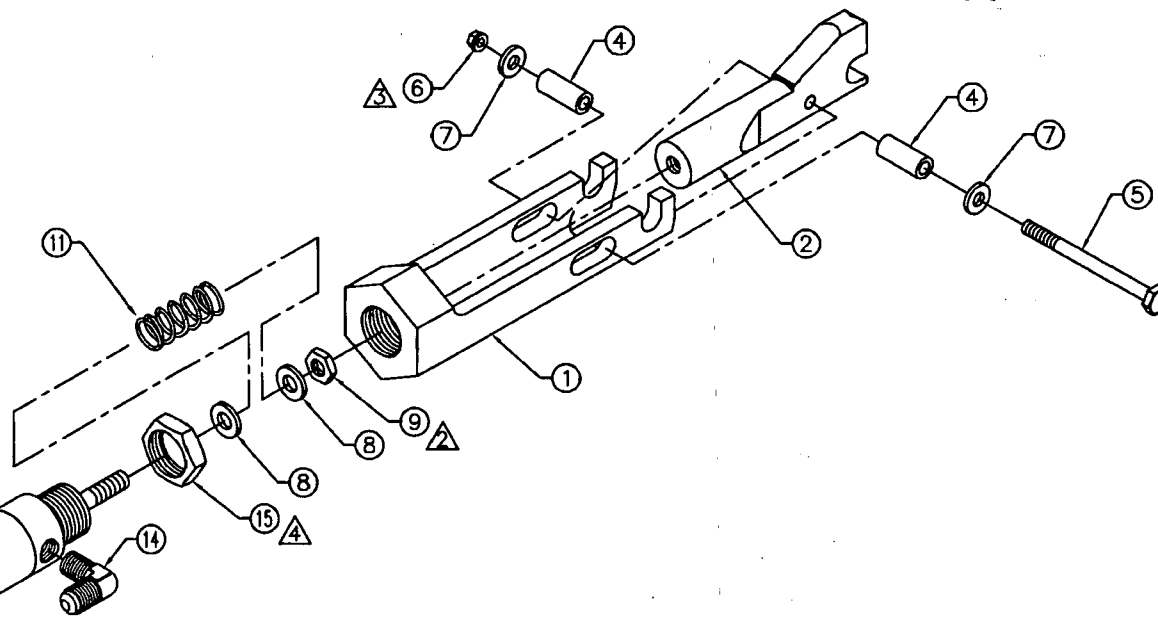


-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.  
 TORQUE 20-25 IN.-LB.  
 TORQUE 50-75 IN.-LB.  
 TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
43287  
RD  
MISSY



				1	1	15	3/4x20 BRASS	CYLINDER NUT					
				1	1	14	MS20822-4	ELBOW					
				1	1	13	AN842-4D	ELBOW					
				1	1	12	41232-200-007-001	CYLINDER					
				1	1	11	71459	SPRING					
				1	1	10	MS16996-23	CAP SCREW					
				1	1	9	AN315-4R	NUT					
				2	2	8	AN960JD416	WASHER					
				2	2	7	AN960JD10	WASHER					
				1	1	6	MS21042-L3	NUT					
				1	1	5	AN3-22A	BOLT					
				2	2	4	41232-200-005-003	SPACER					
				1	1	3	41232-200-002-005	PIVOT ARM					
				1	1	2	41232-200-002-003	LATCH					
				1	1	1	41232-200-002-001	TUBE					
				/			-002	R/H ACTUATOR ASSY					
				/			-001	L/H ACTUATOR ASSY					
				-002	-001	FWD INL.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	

NO. REQ'D PER ASSY				LIST OF MATERIAL																	
<p>PROPRIETARY RIGHTS NOTICE</p> <p>THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. INCLUDING, REPAIRING, OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT AUTHORIZATION FROM ERA AVIATION, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR OR SUBS.</p>				<p>UNLESS OTHERWISE SPECIFIED</p> <p>X±.1</p> <p>YOL±.03</p> <p>XOL±.010</p> <p>ANGLES ±.1°</p>				DRAFTSMAN		D. NELSON		5/20/02		TITLE  STEP ACTUATOR ASSY							
								CHECK		D. MURPHY		5/20/02									
								STRESS						DWG. SIZE		C		SCALE		NONE	
								PROD. ENGR.													
								HEAT TREAT								DWG. NO.		41232-200-001		REV	
FINISH										Era Aviation, Inc.				1F							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries